



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18635-7
Job Sheet 198287



Part No: RBT18635-7

Job Qty: 4 pcs

Part Name: Handle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 9/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18635 Rev 2A IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Conventional Lathe - 1	4 pcs	9/18/19	0.00	0.33		Conventional Lathe - 1		
							Conventional Lathe - 2		
130	QC 2	4 pcs	9/18/19	0.00	0.00		QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S214232



Part: RBT18635-7

Job No: 198287

Serial No/Batch: S214232

Revision: 2A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/17/19

Plex 7/24/19 1:35 PM Dart.lajeunesse.marie

140 QC 8	4 pcs	9/18/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	Done 19-09-19
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
QC 8 - 23					
QC 8 - 57					
170 Outsource - 12 - Black Oxide	4 pcs	9/18/19		GRO002-VC	10 2019-09-19
180 Packaging 2-1 - Receive - B4B	4 pcs	9/18/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP SEP 25 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Plex 7/24/19 1:35 PM Dart.lajeunesse.mari	

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
190 QC 6	4 pcs	9/18/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
					QC 6 - 81	
200 Packaging 3-1 - Stock - B4B	4 pcs	9/18/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	4 pcs	9/18/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 120 - Manufacture as per dwg - Machine as per DWG.

Descriptions: 130 - QC2- Inspect parts off machine FAI/FAIB - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

140 - QC8- Inspect parts - second check

170 - -Issue P/O to Groupe Altech; PO 44538 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required

180 - Receive & Inspect for Damage & Mat'l Certs

190 - QC6- All purchased or subcontracted products

7/24/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

200 - Identify as per dwg & Stock Location: _____

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.750	AISI 1144 Stressproof Round Bar 0.750"	1.0640 ft (.266 ea)	120-Conventional Lathe - 1	S186693

Job Allocations

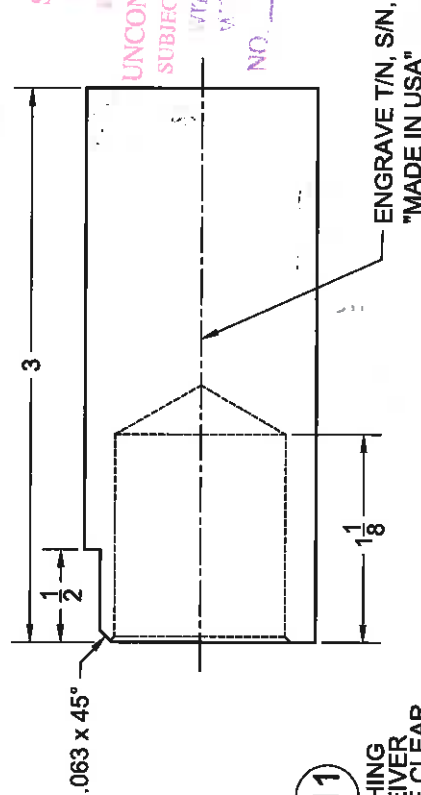
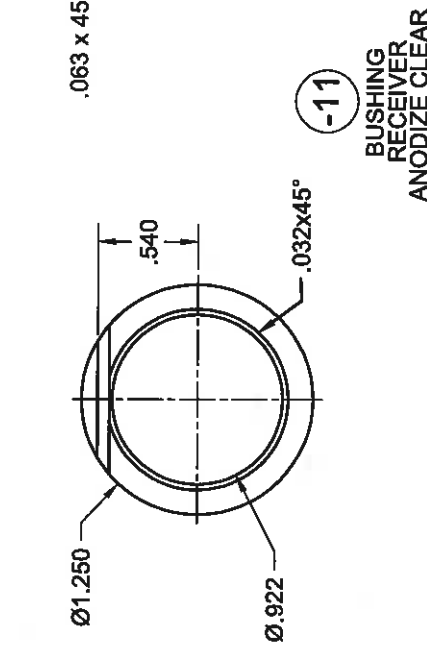
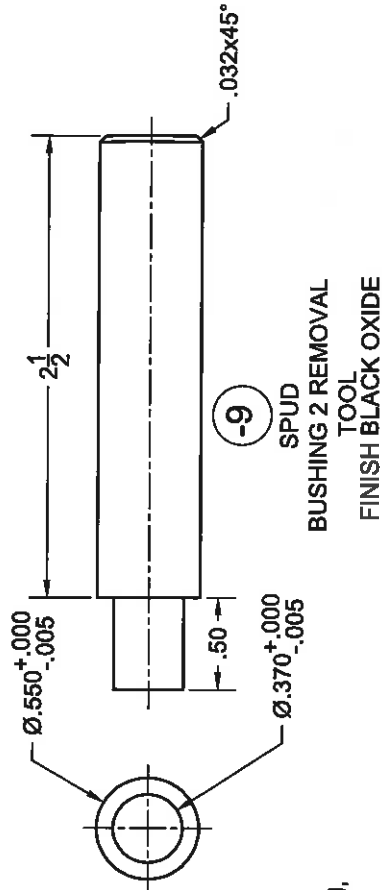
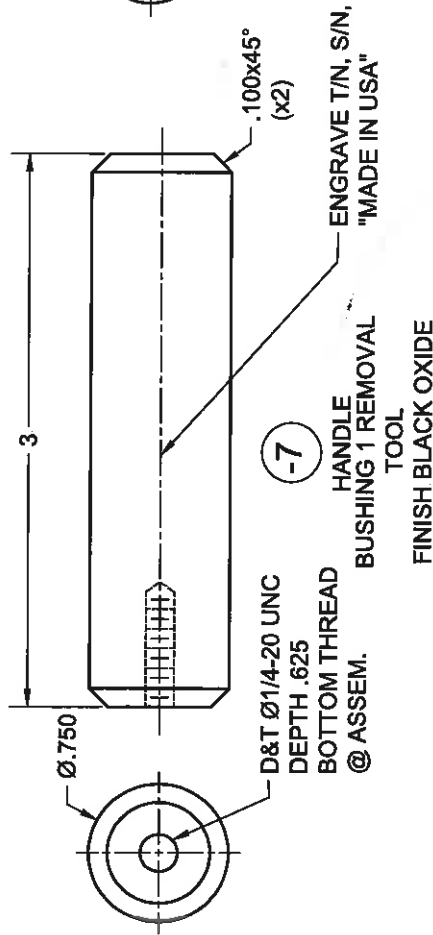
Operation	Component Part	Required	Inventory	Allocated
120-Conventional Lathe - 1	MT-1144-R0.750	1	19	0

Part Specifications

Specifications could not be found.

Plex 7/24/19 1:35 PM Dart.lajeunesse.marie

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
2	CHANGED -11 R.063 TO CHAMFER & -7 MAT. FROM 101B.	1/13/07	
2A	CH'D TITLERBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL. CH'D ENGRAVE NOTE -7 & -11.	1/21/10	RJC
			RW



SHOP COPY

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 195787 M5
1907-01

RED BARN MACHINE

TITLE	T/R BLADE BUSHING REMOVAL TOOL	REV	2A
DWG NO.	RBT18635	DRAWN BY:	PERITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
TOLERANCES ON:			
DECIMALS			
.XXX ± .005			
.XX ± .01			
X ± .1			
FRACTIONS ± 1/32			
ANGLES ± 5°			
UNLESS OTHERWISE SPECIFIED			
1. BREAK ALL SHARP EDGES			
.015 x .45 PR .015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	11-16-06
			SHEET 2 of 2

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS																																																																										
		Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																								
Date :	Sequence #:	QTY Affected :		MRB (QSI042)																																																																										
Description Work Order Deviation		Disposition																																																																												
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>☐</td><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Bending</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>Crushing</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr></table> Other/Details: _____					Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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Completed By Lead hand / Supervisor QC / QA Coordinator 																																																																														



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044538



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044538

PO Date: 9/19/19

Due Date: 9/26/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: **NEEDED FOR MONTH END**

E-MAILED
2019-09-20

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197652	RB6795590-3A	FINGER TIP, BEARING PULLER; GAS PRODUCER TURBINE, POWER TURBINE & COMPRESSOR -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed	-	9/26/19	22 pcs	0 pcs	22 pcs	\$2.40/pcs	\$52.80

X22

SEP 25 2019

DP



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

POHB044538



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	198287	RBT18635-7	Handle -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/26/19	4 pcs	0 pcs	4 pcs	\$2.40/pcs	\$9.60
3	198286	RBT18635-9	Spud -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/26/19	4 pcs	0 pcs	4 pcs	\$2.40/pcs	\$9.60
4	198285	RBT18635-5	Rod -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/26/19	10 pcs	0 pcs	10 pcs	\$2.40/pcs	\$24.00



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PURCHASE ORDER

POHB044538



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	199138	RBW6522A00231-W142AJ-3T-11	Small Knob (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/26/19	6 pcs	0 pcs	6 pcs	\$2.40/pcs	\$14.40
6	198294	RBW6500X01611-W142E-3T-11	Screw Weldment -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Threaded rod -Certificate of Conformity is required	Firmed	-	9/26/19	2 pcs	0 pcs	2 pcs	\$2.40/pcs	\$4.80
	200730			Firmed	-	9/26/19	2 pcs	0 pcs	2 pcs	\$2.40/pcs	\$4.80
Sub Total:							4	0	4		\$9.60
Grand Total:											\$120.00



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Canada

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PURCHASE ORDER POHB044538



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/20/19 11:05 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022592-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022592 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
24-Sep-2019		Jigar Patel		POHB044538					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RB6795590-3A Rev.	RB6795590-3A OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	22	22	0	0	0	
2	RBT18635-7 Rev.	RBT18635-7 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	BLACK-OXIDE CH	4	4	0	0	0	
3	RBT18635-9 Rev.	RBT18635-9 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0	
4	RBT18635-5 Rev.	RBT18635-5 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	BLACK-OXIDE CH	10	10	0	0	0	
6	RBW6500X01611-W142E-3T-11 Rev.	RBW6500X01611-W142E-3T-11 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	2	2	0	0	0	
7	RBW6500X01611-W142E-3T-11 Rev.	RBW6500X01611-W142E-3T-11 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	2	2	0	0	0	

**DAS
81
9-89**

RECEIVED

SEP 24 2019

DART AEROSPACE LTD.

